



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2940-1
Job Sheet 184872



Part No: D2940-1

Job Qty: 10 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/6/18	0.00	0.00	Start Up Machining-1		<i>ML</i>
100	CNC Vertical Machining	10 pcs		11/6/18	0.32	23.81	HAAS1-2		<i>ML</i>
110	QC	10 pcs		11/6/18	0.00	0.00	QC2 Machining-1	<i>KT.</i>	<i>ML</i>
120	QC	10 pcs		11/6/18	0.00	0.00	QC8 Machining-1		<i>ML 18/11/11</i>
130	Crosstubes	10 pcs		11/6/18	0.00	1.25	Crosstubes-2		<i>AB 18-11-18 DAS</i>
140	QC	10 pcs		11/6/18	0.00	0.00	QC5		<i>NOV 20 2018 68</i>
170	Packaging	10 pcs		11/6/18	0.00	0.00	Packaging3-1	<i>LG051</i>	<i>AB 18-11-22 9-89</i>
180	QC21-SA	10 Ea		11/6/18	0.00	0.00	QC21		<i>DAS NOV 22 2018</i>

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG052 *138352 exp 4/19*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

5078318x1

134876x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK081	5	3	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

5	3.250 Support	1.633Inches	+ 0.040 - 0.000	1.673 1.633
6	3.250 Support	1.493Inches	+ 0.020 - 0.000	1.513 1.493
7	3.250 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040
8	3.250 Support	0.188Inches	+ 0.005 - 0.000	0.193 0.188
9	3.250 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140
10	3.250 Support	2.518Inches	+ 0.020 - 0.000	2.538 2.518
11	3.250 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040
12	3.250 Support	0.010Inches	+ 0.010 - 0.000	0.020 0.010
13	3.250 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140
14	3.250 Support	0.350Inches	+ 0.100 - 0.000	0.450 0.350
15	3.250 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240
16	3.250 Support	0.150Inches	+ 0.020 - 0.000	0.170 0.150
17	3.250 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053
18	3.250 Support	101.640Inches	+ 4.000 - 0.000	105.640 101.640
19	3.250 Support	0.260Inches	+ 0.007 - 0.000	0.267 0.260
20	3.250 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053
21	3.250 Support	4.118Inches	+ 0.020 - 0.000	4.138 4.118

Plex 10/17/18 12:39 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S124991

Part: D2940-1
Job No: 184872
Serial No/Batch: S124991

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/06/18

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1270 Aberdeen Street
Markham, ON L3R 9K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification ☐
		QC / QA Coordinator Approval ☐

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AD	3.510	3.530		3.520	3.521	3.520	3.520	3.517
AE	1.633	1.673		1.657	1.659	1.660	1.660	1.665
AF	1.493	1.513		1.500	1.501	1.500	1.500	1.509
AG	0.040	0.060		0.048	0.050	0.049	0.048	0.050
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AJ	2.518	2.538		2.525	2.526	2.526	2.526	2.521
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AM	0.140	0.160		0.160	0.160	0.160	0.160	0.159
AN	0.350	0.450		0.380	0.380	0.375	0.375	0.365
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AT	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: *KJ*

Date: 2018-11-05

Audited by: *[Signature]*

Date: 18/11/11

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>[Signature]</i>

10-11-0102

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DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	X6	X7	X8	X9	X10
HAAS Section								
AA	0.240	0.260		0.250	R.250	R.250	R.250	R.250
AB	0.490	0.510		0.500	R.500	R.500	R.500	R.500
AC	0.140	0.160		0.150	.155	.155	.155	.155
AD	3.510	3.530		3.512	3.514	3.516	3.515	3.516
AE	1.633	1.673		1.665	1.668	1.666	1.665	1.666
AF	1.493	1.513		1.510	1.507	1.505	1.510	1.511
AG	0.040	0.060		0.051	.048	.052	.051	.049
AH	0.188	0.193		0.188	.1908	.1908	.1908	.1908
AI	0.140	0.160		0.150	.152	.151	.151	.150
AJ	2.518	2.538		2.522	2.533	2.536	2.535	2.536
AK	0.040	0.060		0.050	.045	.040	.040	.040
AL	0.010	0.020		0.010	.010	.010	.010	.010
AM	0.140	0.160		0.150	.155	.158	.158	.156
AN	0.350	0.450		0.358	.370	.372	.373	.377
AO	0.240	0.260		0.250	.250 R	.250 R	.250 R	R.250
AP	0.150	0.170		0.150	.160	.152	.153	.152
AQ	0.053	0.073		0.063	.063 R	.063 R	.063 R	R.063
AR	101.64	105.64		103.64	103.6	103.6	103.6	103.6
AS	0.260	0.267		0.261	.261	.261	.261	.261
AT	0.053	0.073		0.063	.063 R	.063 R	.063 R	R.063
AU	4.118	4.138		4.126	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: <i>KF</i>	Date: 2018-11-05
Audited by: <i>[Signature]</i>	Date: 11/11/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

